July 14, 2009 12:29:07 PM

Item ID:

D3126-5

Accept

Setup Start

Stop



Page 1

Revision ID: Item Name:

Start Date: 7/15/09

A1

Bracket

QC:

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 7/15/09

Process Plan: MF

Date: 09-07-15 Tooling:

Date: _____

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/

Operation

Set Up/ **Run Hours**

Draw Number

Draw Rev.

Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Work Center ID Draw Nbr

Revision Nbr

Description

D3126

Rev A1

100

FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3126 □Dwg Rev:

0.00

0.00

<u>A(</u> _ □Prog Rev: <u>A(</u> □2-

图 9-7-31

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Deburr if necessary

0.00

Memo

0.00

枢 9-7-3]

120

QC

QC8- Inspect parts - second check

Memo

0,002>501/07/31

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
	:												
	l						<u> </u>						

Part No:	_ PAR #:	Fault Category:	NCR: Yes	lo DQA :	Date:
			QA: N/	C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
								,
		1 495 504 504						
								

NOTE: Date & initial all entries

se -58 SE

A1



July 14, 2009 12:29:07 PM

Item ID:

D3126-5

Accept

Setup Start

Stop

Stop



Revision ID: Item Name:

Start Date:

Bracket

Required Date: 7/15/09

7/15/09

QC:

Start Qty: 20.00

Reg'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Start

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours** Draw Number Plan Code Accept Qty

38 ø

Reject Qty

Reject Insp. Number Stamp

130

Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

1-Form on CNC brake as per D3126 using Jig D3126T1 □ Identify as D3126-5□2-Scribe Dart P/N as shown on Dwg D3126

Date:

Draw

Rev.

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

Packaging

Packaging

Identify as per dwg & Stock Location: 235A

0.00

Memo

Memo

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					

Part No:	_PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	Verification	Approval	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
				140.4				

. NOTE: Date & initial all entries

Work Order ID 50345

July 14, 2009 12:29:07 PM



Page 3

Item ID:

D3126-5

Revision ID: A1

Item Name: Bracket

Start Date: 7/15/09 Start Qty: 20.00

Required Date: 7/15/09

Req'd Qty: 20.00



Accept



Setup Start

Stop

Start

Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date: **Tooling:**

Date: SPC (Y/N):

Date: Date:

Stop

Run

Sequence ID/

Work Center ID

Description

Operation

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Draw Number

Draw Rev.

Plan Code Accept Qty

Reject Reject

Insp. Number Stamp

160

QC Quality Control

Memo

0.00

Qty

U 94.0911

W/O:			WORK ORDER CHANGES						
DATE	STEP	F	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					•				
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	_ Date: _		
				QA:	N/C Close	d:	_ Date: _		
NCR:		•	WORK ORDER NON-CON	FORMANCE (NC	R)				

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Anneous		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						;	t.	
					;			
					چنه			
		,						

. NOTE: Date & initial all entries

Picklist Print

July 14, 2009 12:29:06 PM

Work Order ID: 50345

Parent Item: D3126-5RevA1

Parent Item Name: Bracket

Comments:



Start Date: 7/15/09

Start Qty: 20.00

Required Date: 7/15/09

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Pr	 ast ocation	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S22GA	FILL BORIS 201 (BB)	Purchased	No	 ·	110	sf	53.4147	2.3389	38		

304/316 .032 Sheet

Warehouse	Loc Qty	Loc Code		
Location				
Main Warehouse				
MAT	53.41473684			
109023	32.45			
109057	17.6647368		109057	B9-7-31
109088	3 3		•	•

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector						

Part No:	PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:
			QA: N	/C CI	osed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE		Description of NC	Corrective Action Section B			Varification			
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
							·		
								,	

NOTE: Date & initial all entries

				·	Work Order:	50345			
DART AEROS Description:	RRACKE				Part Number:	,			
Inspection Dwg		ARTICI E IN	ICDECTI	ON CHE	CKLIST	Page 1 of 1			
	FIRST ARTICLE INSPECTION CHECKLIST X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of inspection	Comments			
.300	4 ,018	1204	<i>></i>						
.800	4-010	.803	k			<u> </u>			
	4 .024	.958	*						
1.09 2.33	4 .036	1,091	X9						
2 835	1/2 .010	7.835	X-						
1.830	4/010	1.831	凇	,	·				
1.910	4 .010	1.913	×						
1525	4 -010	.576	X						
2,300	7010	3'300	*						
2.835	4 .010	768.5	*	·	·				
4.600	4 .010	4.599	3 1						
023.2 EE0,	7 .010 7 .010	2,683	×						
ور ۱۰۰	/								

Measured by:	מט	Audited by:	2	Prototy	pe Approvai:	1	/
Date:	9-7-31	Date:	09/07/31		Date:		4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

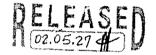




0.45

RO.128

	DESIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
1	CHECKED	APPROVED	DRAWING NO.	٠,		REV.	A	
	71.	4	D3126		SHEET			
	DATE		TITLE	•		SCA	LE	
	02.04.17		BRACKET -			1	:2	



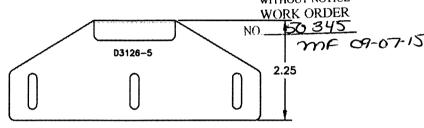
2.09

(REF)

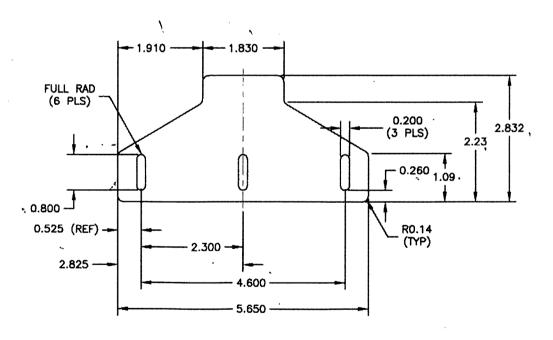
SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER



<u>D3126-5 BRACKET</u> REPLACES PREMIER P/N B30-23000-269



D3126-5 BRACKET FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) SCRIBE DART P/N D3126-5 AS SHOWN

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